

Date: Wednesday, 12/7/2005 12:44:08 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PACKER
Job Number	: 25155		
Estimate Number	: 10225		
P.O. Number	: N/A	Part Number	: D2150
This Issue	: 12/7/2005 S.O. No. : N/A	Drawing Number	: D2150 REV. A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 24492	Material	: N/A
Written By	: SEE COMMENT BELOW	Due Date	: 12/15/2005 Qty: 50 Um: Each
Checked & Approved By	: SEE ABOVE DATE & USER.		
Comment	: Est C 00.11.27 Re-format (mpp 2101) EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M2024T3S040	2024-T3 .040 sheet
-----	-------------	--------------------



Comment: Qty.: 0.0263 sf(s)/Unit Total : 1.3125 sf(s)
 Material: 2024-T3 (QQ-A-250/4) 0.040" thick
 (M2024T3S.040) Batch: M19059

55

FF 05-12-07

2.0	SHEAR	SHEAR
-----	-------	-------



55

Comment: SHEAR
 Cut blank: 2.300" x 1.559" +/-0.005"

FF 05.12-07

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio FA109 and Dwg D2150
 Identify as D2150

made by Rand

mldod 01/30 55
53

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
-----	-----	--------------


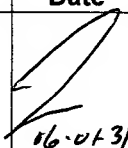
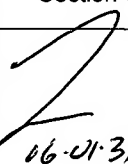

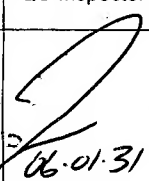


Comment: SECOND CHECK

PTO 45
 01.31.
 06.01.31.
 PTO 45

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2150 PAR #: N/A Fault Category: Prod/Pas. Ass ^{material} NCR: Yes No DQA: 1P Date: 06/02/22
 QA: N/C Closed: 1P Date: 06.02.22

NCR: <u>25155</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-01-31	3	8 parts scrap. holes of .171, location of dimensions are too wide, won't fit hinge, holes don't line up.		Scrap: destroy.	 06-01-31	 06-01-31		 06-01-31

NOTE: Date & initial all entries

Date: Wednesday, 12/7/2005 12:44:08 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PACKER

Job Number: 25155

Part Number: D2150

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr

ml 06/01/30

53

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

JAD 06/02/08 45

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Q.M 06-02-20

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FC 060220 45

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: ST 026

P 06/2/21 45

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

545 06/02/22 45

06/02/22 (45)

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	25155
Description: Packer		Part Number:	D2150
Inspection Dwg: D2150 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.740	+/-0.010					
2.050	+/-0.010					
0.231	+/-0.010					
1.217	+/-0.010					
1.559	+/-0.010					
2.300	+/-0.010					
1.560	+/-0.010					
0.250	+/-0.010					
1.328	+/-0.010					
0.342	+/-0.010					
Ø0.098	+0.005/-0.000					
Ø0.171	+0.005/-0.000					
0.040	+/-0.010					

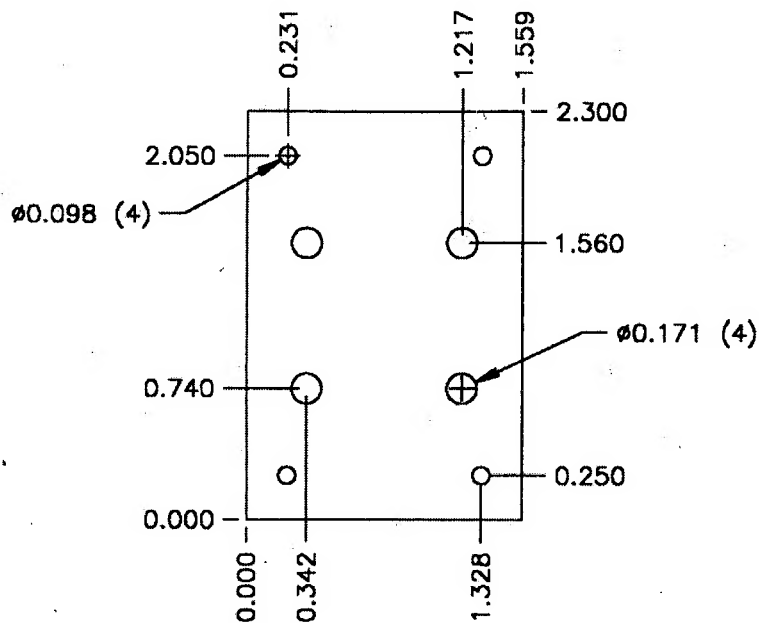
Measured by:		Audited by:		Prototype Approval:	N/A
Date:		Date:		Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.28	New Issue	KJ/JLM	



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	K HAND	DRAWING NO.	REV. A
CHECKED	APPROVED	D2150	SHEET 1 OF 1
DATE	TITLE	PACKER	SCALE
95:05:01			1:1

RELEASED
96/06/13 BWS



SHOP COPY
RETURN TO
ENGINEERING
1 FOLDER COPY
WORK COPY
NO. 25155

MATERIAL: 2024-T3, 0.040 THICK
FINISH: WHITE POWDER COAT HI-GLOSS